

Date: Thursday, 12/20/2007 3:17:12 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	MIRROR BRACKET		
Job Number	36466A			Part Number	D2161204		
Estimate Number	10142			Drawing Number	D2161 REV B2		
P.O. Number				Project Number	N/A		
This Issue	12/20/2007	S.O. No.		Drawing Revision	B2		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	1/15/2008	Qty:	5 Um: Each
Previous Run	29082A						
Written By	<i>10/07/12/21</i>						
Checked & Approved By							
Comment	Est Rev:A New Issue 05-11-01 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	36466A01	MIRROR BRACKET	
	Comment: Sub-Component MIRROR BRACKET D2013-5 B <u>36466 A01</u>		<i>FC 08 01 14 (S)</i>
2.0	36466A02	MIRROR BRACKET	
	Comment: Sub-Component MIRROR BRACKET D2013-6 B <u>36466 A02</u>		<i>FC 08 01 14 (S)</i>
3.0	36466A03	ARM	
	Comment: Sub-Component ARM D2037-101 B <u>36466 A03</u>		<i>FC 08 01 14 (S)</i>
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1		
	1-Assemble on Jig DT8065 as per Dwg D2161		<i>FC</i>
	2-Weld as per Dwg D2161 Identify as D2161-204		<i>FC 08/01/14 (S)</i>
5.0	DO NOT USE	WELD INSPECTION	
	Comment: WELD INSPECTION		<i>QC5=> S ord.15 QC9=> PD 080-15 (S)</i>
			<i>(X2)</i>
			<i>(X2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2161-204 PAR #: _____ Fault Category: Prod/Fab Large NCR: Yes No DQA: LD Date: 08/01/28
 QA: N/C Closed: ST Date: 08/01/28

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/15	# 4.0	3 off complete mirror brackets were welded wrong. The "Equal Distance" is off by at least $3/16"$.	WD 08/01/15	SCRAP and Destroy no replace. QTY <u>43</u>	FC 08/01/15	08/01/15	WD 08/01/15	S 08/01/15
		R.C. HUMAN ERROR						
08/01/15	# 4.0	I completed mirror bracket were welded wrong. The "Equal Distance" is off by $1/8"$	VE 08.01.15	Part is acceptable. This one time only	FC 08/01/15	08/01/15	VE 08.01.15	S 08/01/15

NOTE: Date & initial all entries R.C. HUMAN ERROR

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Drawing Name: MIRROR BRACKET

Job Number: 36466A

Part Number: D2161204

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M100 700



(QX)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M100 08/01/18

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(31)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

01/01/18 50

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08.01.22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



le 08.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

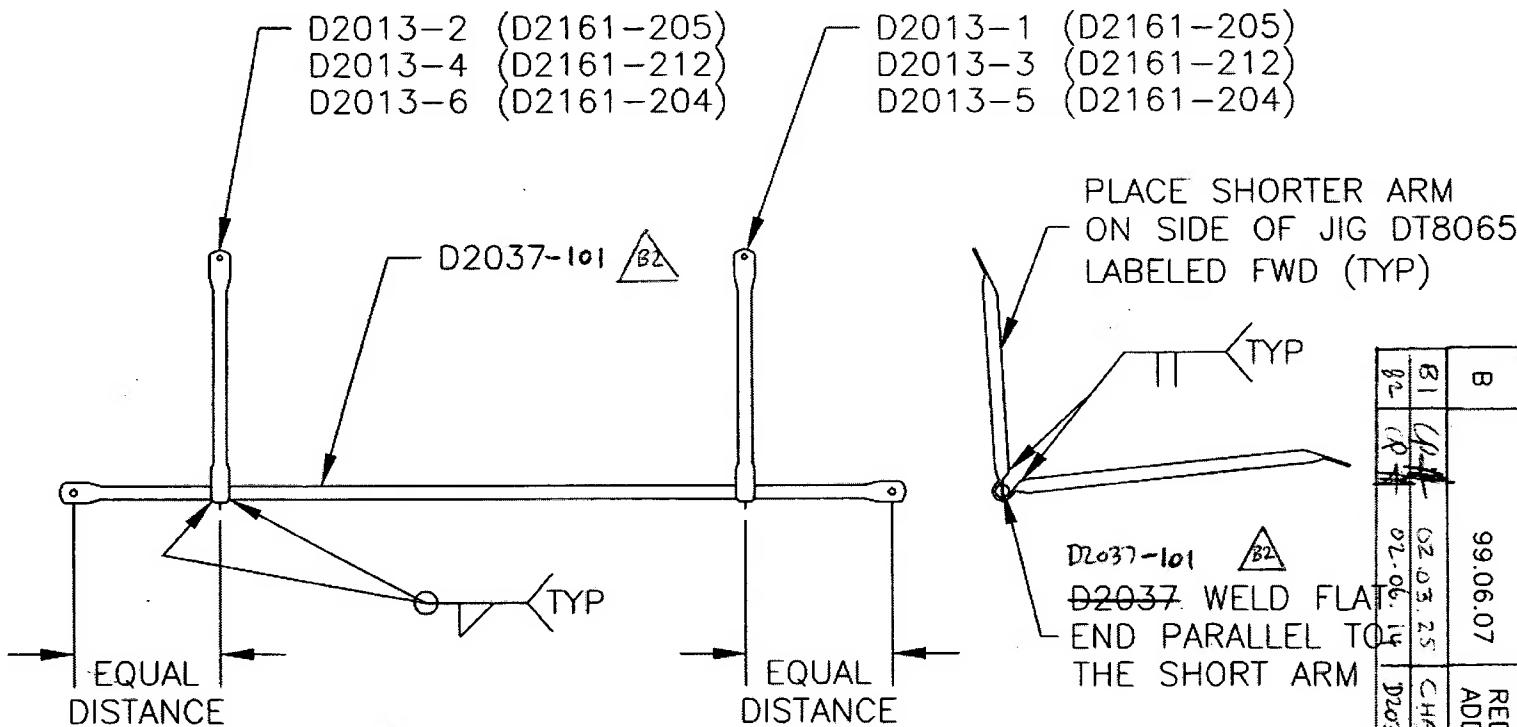
NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY RJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED <i>KE</i>	APPROVED <i>JK</i>	DRAWING NO. D2161	SHEET 1 OF 1
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS	
A 93.04.29	NEW ISSUE		
B 99.06.07	REDRAWN FOR CLARITY ADDED - 204/-205/-212 DESIGNATIONS <i>GP-1</i> <i>GP-1</i> <i>GP-1</i>	CHANGES PINS <i>GP-1</i> <i>GP-1</i> <i>GP-1</i>	
G1 G2	02.03.25 02.06.14	D2037-101 WELD FLAT END PARALLEL TO THE SHORT ARM <i>GP-1</i>	

RELEASED
KE 99.06.10

DETAIL OF D2161-204
 DETAIL OF D2161-205
 DETAIL OF D2161-212



NOTE: WELD ASSEMBLY
USING JIG DT8065

POWDER COAT ASSEMBLY BLACK
 SPARKLE (4.3.5.3) PER DART QSI 005 4.3
 POWDER COAT BLACK SANDTEX (4.3.5.7) PER
 DART QSI 005 4.3
JK

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 WITHOUT NOTICE
 WORK ORDER
 NO. 3646A